

split

Date: Tuesday, 10/02/2009 3:10:10 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 500 MIRROR ASSEMBLY
Job Number	: 45734	Part Number	: D500560041
Estimate Number	: 11970	Drawing Number	: N/A
P.O. Number	:	Project Number	: N/A
This Issue	: 10/02/2009 S.O. No. :	Drawing Revision	: D
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : SMALL /MED FAB	Due Date	: 28/02/2009
Previous Run	: 45288	Qty:	4 Um: Each
Written By	:		
Checked & Approved By	: <u>JD 09.02.10</u>		
Comment	: Est Rev:E 03.10.15 Reformat; Removed D2057 KJ/RF Est Rev:F 08-05-27 as per ECN1195p DD verified by:EC		

3

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D500-560-041 CHC006

New mirror Rev.
chc006

2.0	D1048	Saddle
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D1048	Clamp	35037 x 7

FF 09-03-05

4

3.0	D1049	Saddle
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D1049	Saddle	B39919

FF 09-03-05

4

4.0	D2010101	Mirror Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2010-101	Bracket	B39920

FF 09-03-05

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 500 MIRROR ASSEMBLY

Job Number: 45734

Part Number: D500560041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D2010103	Mirror Arm, 500
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2010-103	Bracket	B40 667
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FF 09-03-05

(4)

6.0	D2011101	6" Mirror
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2011-101	Mirror	B43793
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FF 09-03-05

(4)

7.0	AN526C1032R10	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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4	AN526C1032R10	Screw	M110049
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FF 09/03-05

(4)

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per drawing D500-560

FF 09/03/05

(3)

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SM 09/03/10

(3)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 500 MIRROR ASSEMBLY

Job Number: 45734

Part Number: D500560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN3-4A

Bolt

M103411 x 12

SS 09/03/10 (3)

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09/03-10 (3)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D500-560-041

Location:

PPP Rev:

Rev G

09/03/10 (3)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/10

Job Completion



U 09.03.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

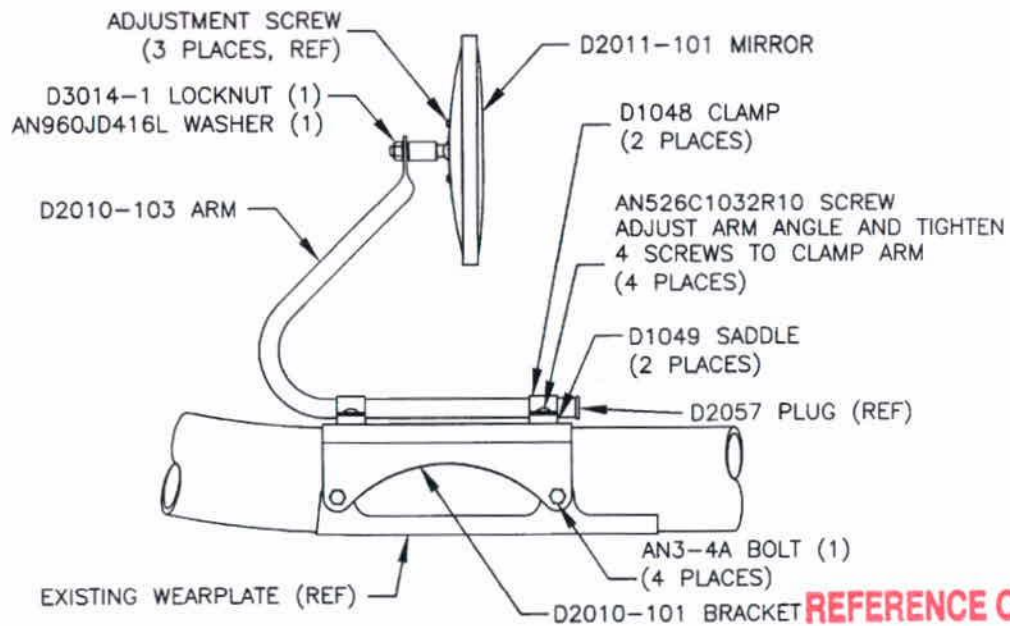


Figure 2: Installation of D500-560-041 Cargo Mirror Assembly

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-560-041 Cargo Mirror Assembly	1.0 lb 0.45 kg	-45 in -1.14 m	-45 lb-kG -0.51 m-kG	24 in 0.61 m	24 in-lb 0.27 m-kG

5. PARTS LIST

Qty	Part Number	Description
X	D500-560-041	CARGO MIRROR ASSEMBLY
1	D2011-101	MIRROR
1	*D3014-1	LOCKNUT
1	*AN960JD416L	WASHER
2	D1048	CLAMP
2	D1049	SADDLE
1	D2010-101	BRACKET
1	D2010-103	ARM
4	AN3-4A	BOLT
4	AN526C1032R10	SCREW (OR AN526-1032R10)

* PARTS ARE INCLUDED WITH D2011-101 MIRROR